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004945

648.4704
Job Sheet 180407



Part No: 648.4704

Job Qty: 1 ea

Part Name: C45 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM & OOPM-C45 Rev 4 (648.4704) IPP Rev A 18.04.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Small Fab-3		
100	Small Fab	1 pcs	8/7/18	8/7/18	0.00	1.00	Small Fab-3		
120	QC	1 pcs	8/7/18	8/7/18	0.00	0.00	QC4		
121	DC	1 pcs	8/7/18	8/7/18	0.00	0.00	DC		
130	Packaging	1 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3-		
140	QC21-FG	1 Ea	8/7/18	8/7/18	0.00	0.00	QC21		

Part Op 100 - Pick bag and tag

Descriptions: 121 - Supply owner's & overhaul procedures manual

M.A. sold

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1149F0463P	Washer	3 Ea (3 ea)	90-Start up Operation	5078780
NAS1149F0563P	Washer	8 Ea (8 ea)	90-Start up Operation	5067901
188-FPSS-1/4 20-3/8	see P/N 188-FPSS-1/4-20-3/8	2 Ea (2 ea)	100-Small Fab	5075264
188-FSCS-1032-5/8	Screw	4 Ea (4 ea)	100-Small Fab	5078378
600.1309-A	Label	1 Ea (1 ea)	100-Small Fab	5072105
600.1312	Caution Sticker	1 Ea (1 ea)	100-Small Fab	5072105
AN4-23A	Bolt	2 Ea (2 ea)	100-Small Fab	BF123434-40
AN5-21A	Bolt	4 Ea (4 ea)	100-Small Fab	5093603
C2-14-2	Label Rivets	2 Ea (2 ea)	100-Small Fab	5040661
C45-10-1	Spring Pin	1 Ea (1 ea)	100-Small Fab	5040658
C45-10-2	Lock Spring	1 Ea (1 ea)	100-Small Fab	5099970
C45-11-2	Locating Pin	2 Ea (2 ea)	100-Small Fab	5054326
C45-12-1	Lock Bushing	2 Ea (2 ea)	100-Small Fab	5091795
C45-12-6	Retaining Ring	2 Ea (2 ea)	100-Small Fab	5054986
C45-13-1	Keeper Bushing	2 Ea (2 ea)	100-Small Fab	5101278
C45-13-2	Spacer	2 Ea (2 ea)	100-Small Fab	5097746
C45-13-5 P	Keeper Spring	1 Ea (1 ea)	100-Small Fab	5029308
C45-3-1	Radial Bearing	2 Ea (2 ea)	100-Small Fab	5091767
C45-3-12	DU Bearing	1 Ea (1 ea)	100-Small Fab	5091768
C45-3-2-1	Snap Ring	2 Ea (2 ea)	100-Small Fab	5097098
C45-3-4-1	Retaining Ring	4 Ea (4 ea)	100-Small Fab	5068056
C45-3-5	Spacer	2 Ea (2 ea)	100-Small Fab	5097745
C45-3-8A	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab	5076197

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		MRB (QSI042) Approval			
Description		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			

DART AEROSPACE
 Container No: S101081
 Part: 648.4704
 Job No: 180407
 Serial No/Batch: S101081
 Revision: 4
 Inspector: _____
 Exp Date: _____
 Instructions: _____

 Date: 08/10/18

Root Cause			
Environment	☐	No Re	☐
Design	☐	Operi	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Cracks	Inspection Incomplete/Unqualified	Loss/Surge program
Crimp/Kink/Ripple/Wave	Contamination	wrong Stock Pulled
Cuffs	Countersink	Out of Sequence
Crushing	Cut Too Short	Off-set
Heat Treat	Instructions Incomplete/Unclear	Mislabeled
Wave/Twist in Tube	Drill Holes	Fit/Function
Marks/Chatter		Misaligned/off center

OTHER : _____

C45-3-8B	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab
C45-3-9	Lever Spring	1 pcs (1 ea)	100-Small Fab
C45-4-1	Trunnion Bushing	2 Ea (2 ea)	100-Small Fab
C45-5-1	Lever Stop Pin	1 Ea (1 ea)	100-Small Fab
C45-7-1	LOADBEAM BUMPER	1 Ea (1 ea)	100-Small Fab
C45-7-2	Lock Bumper	2 Ea (2 ea)	100-Small Fab
C45-8-4	Solenoid Cover Gasket	1 Ea (1 ea)	100-Small Fab
MS21044N5	Nut	4 Ea (4 ea)	100-Small Fab
MS27039-4-08	Screw	1 Ea (1 ea)	100-Small Fab

5078801
 5089520
~~5078803~~ 5078803
 5040657
 5029332
 5095587
 5094821
 5097089
 5097087

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1149F0463P	3	747	0
	NAS1149F0563P	8	626	0
100-Small Fab	188-FPSS-1/4 20-3/8	2	0	0
	188-FSCS-1032-5/8	4	377	0
	600.1309-A	1	0	0
	600.1312	1	22	0
	AN4-23A	2	588	0
	AN5-21A	4	73	0
	C2-14-2	2	206	0
	C45-10-1	1	91	0
	C45-10-2	1	11	0
	C45-11-2	2	78	0
	C45-12-1	2	16	0
	C45-12-6	2	84	0
	C45-13-1	2	13	0
	C45-13-2	2	82	0
	C45-13-5	1	95	0
	C45-3-1	2	18	0
	C45-3-12	1	12	0
	C45-3-2-1	2	54	0
	C45-3-4-1	4	156	0
	C45-3-5	2	78	0
	C45-3-8A	1	57	0
	C45-3-8B	1	38	0
	C45-3-9	1	0	0
	C45-4-1	2	48	0
	C45-5-1	1	41	0
	C45-7-1	1	0	0
	C45-7-2	2	12	0
	C45-8-4	1	0	0
	MS21044N5	4	139	0
	MS27039-4-08	1	78	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					